

of a lug or projection, the relation of this hole to the finished surfaces used for locating being immaterial. The piece of work, being a casting, would naturally be liable to variations between the finished surfaces and the center of the lug, particularly if there are other surfaces and lugs to which the already finished surfaces must correspond, and in such a case, the fixed bushing for drilling a hole that ought to come in the center of the lug, might not always suit the casting. In such a case, so-called "floating" bushings, as shown in Fig. u, are used. The screw

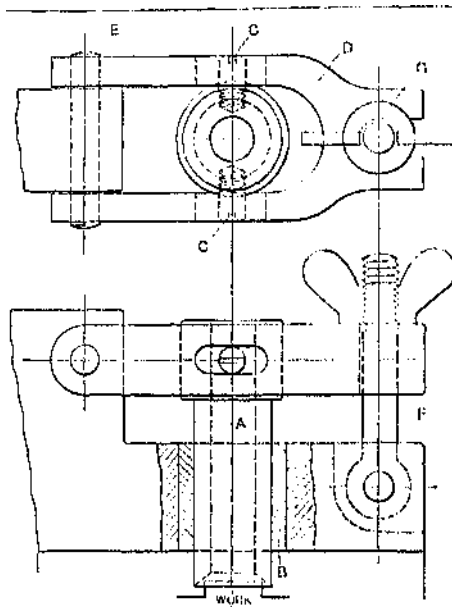


Fig. 10. Sliding Bushing for Locating and Clamping Work

^ is conically recessed and locaUs from the projection

On the-casting. It is fitted into another cylindrical piece *B*, provided with a flange on one side. The piece /?, again, sets into the hole *C* in the jig body *D*, this hole being large enough to permit the necessary adjustment of the jitf bushing.

When the bushing has been located concentric with the lug *E* on the work, the nut *F*, having a washer (/ under it., is tightened. The flange on piece *B* and the washer *G* must be large enough, t<} cover the hole *C* even if *B* is brought over against the side